

Date: Thursday, 6/21/2007 2:29:08 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WEARPLATE
Job Number : 33055	
Estimate Number : 10288	
P.O. Number : <u>NA</u>	Part Number : D25771
This Issue : 6/21/2007 S.O. No. : <u>NA</u>	Drawing Number : D2577 REV E
Prsht Rev. : NC	Project Number : N/A
First Issue : <u>NA</u> Type : SMALL /MED FAB	Drawing Revision : E
Previous Run : 32649	Material : <u>NA</u>
Written By : _____	Due Date : 7/10/2007 Qty: 30 Um: Each
Checked & Approved By : <u>AD 07 06 22</u>	
Comment : Est: E 02.09.24 Re-format; Incorporated D2577-101-11 K	
J/R/F	
est F 06.09.11 now waterjet EC	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M1010S16GA	1010/1025/A21/6aA SHEET
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Comment: Qty.: 0.8474 sf(s)/Unit Total : 25.4205 sf(s)  
 1010/1025/A21/6aA SHEET

B# M104948

B 07-07-22

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET  
 1-Cut as per Dwg D2577 (D2577-101 detail)  
 Dwg Rev: E  
 Prog Rev: E

(30)

2-Deburr if necessary

B 07-07-22

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	----------------------------------------



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

B 07-07-22

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

B 07-07-22

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE  
 1-Form on brake as per Dwg D2577 using DT8155 and DT8179  
 2-Form joggle as per Dwg D2577 using DT8157  
 3-Identify as D2577-1  
 4-Deburr if nesasary

FF 07-08-08

30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: AD Date: 07/08/28  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 6/21/2007 2:29:09 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 33055

Part Number: D25771

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

EP 07/08/08

created

(30)

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld hard surface using DT8308A & DT8308B as per Dwg D2577

Qty Description

Batch

A/R 7560 Hardcoat Rod

M104721 / M105138 FC 07/08/23 (30)

8.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07/08/27 (30)

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M-1 07/08/28

(30X)

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 07/08/28 (30)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FP-15

FL 07/08/28 (30)

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

D 07/08/28

Job Completion



h 07/08/28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries





RELEASED  
00 09 22

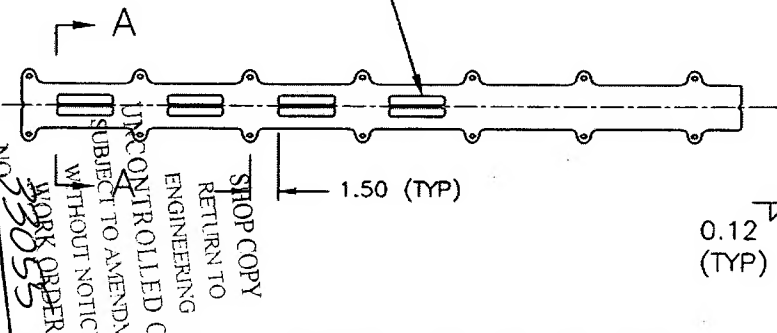
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CHECKED	APPROVED	HAMKESBURY, ONTARIO, CANADA
00.09.22	00.09.22	REVISIONS
A	96.09.16	NEW ISSUE
B	96.12.04	ADD HARDCOAT WELDS
C	97.05.30	CHANGE HOLES TO OBROUNDS
D	98.08.17	CORRECTED DIMENSIONS ON -1 & -3
E	00.09.22	ADD D2577-101/-11/-13 INCORPORATE DE09176

7560 HARDCOAT WELD  
4.0 LONG  
0.063 TO 0.125 HIGH  
(TYP. 11 PLS.)  
WELD AFTER BENDING AS  
ILLUSTRATED PER DT8308

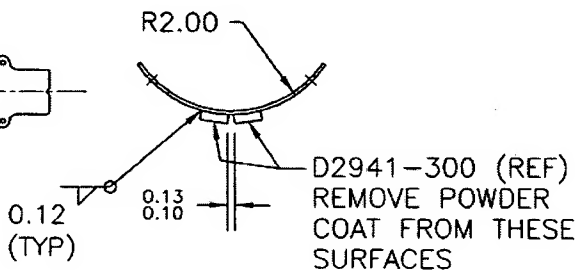


D2577-1 & D2577-3 WEARSHOE  
MAKE FROM D2577-11 AND D2577-13 RESPECTIVELY  
FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

D2941-300  
SHWAYDER WEAPADS  
(8 PLACES)



SECTION A-A  
SCALE 1:5

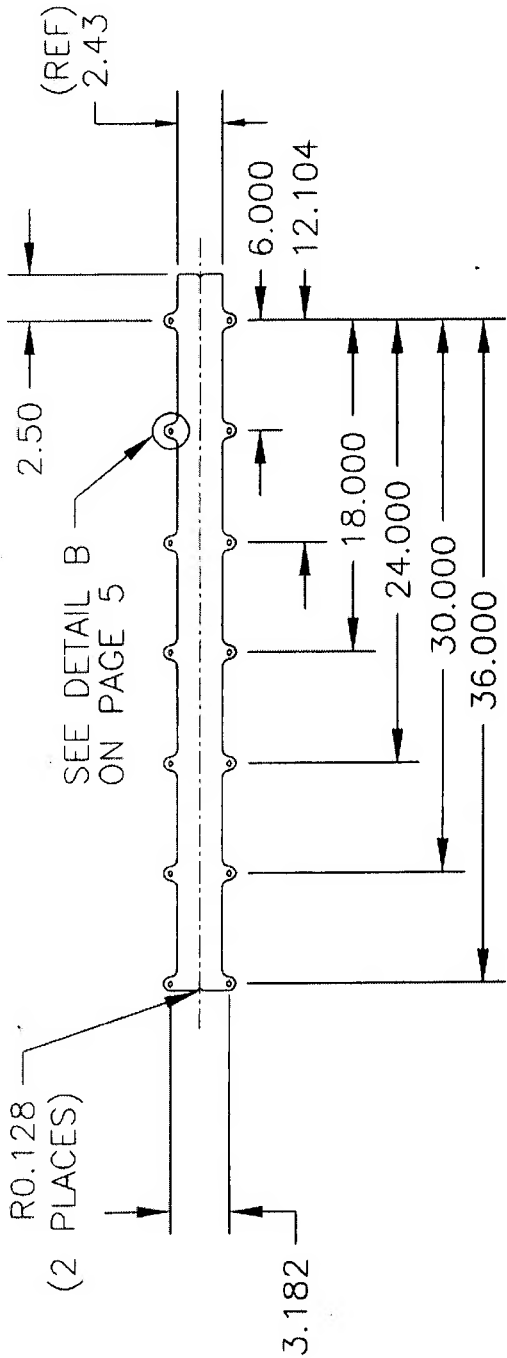


D2577-21 & D2577-23 WEARSHOE  
MAKE FROM D2577-11 AND D2577-13 RESPECTIVELY  
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TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

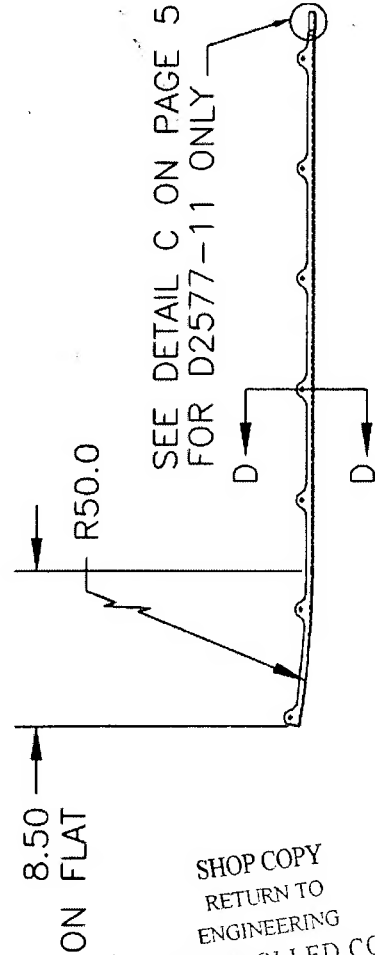


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CHECKED #	APPROVED #	DRAWING NO. D2577	REV. E SHEET 2 OF 5
DATE 00.09.22		TITLE WEARSHOE	SCALE 1:10

RELEASED  
00.09.26 #



D2577-101 FLAT PATTERN  
BREAK ALL SHARP CORNERS 0.010 TO 0.020  
MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570  
SERIES STEEL 0.063 THICK  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



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WORK ORDER  
NO. 33055

D2577-11 & D2577-13 LONGITUDINAL BEND  
MAKE FROM D2577-101  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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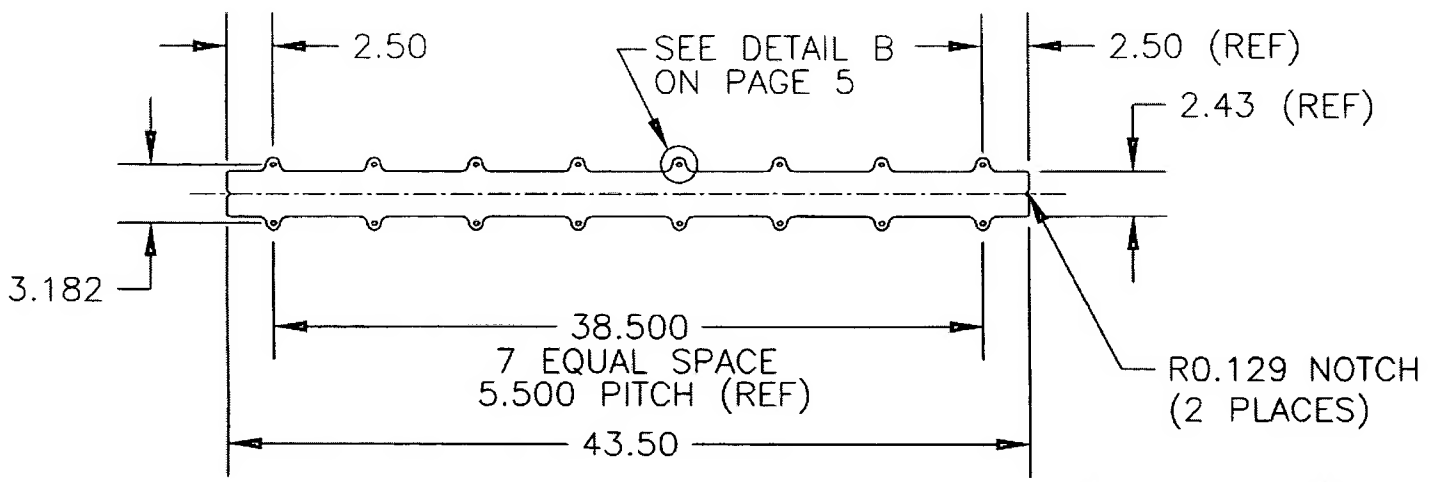
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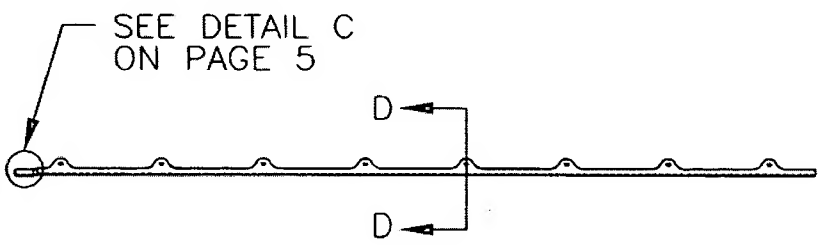
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CHECKED	✓	APPROVED	✓	
DATE	00.09.22	DRAWING NO.	D2577	
TITLE				WEARSHOE
SCALE				1:10

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00.07.26

D2577-5 FLAT PATTERN



D2577-5 LONGITUDINAL BEND



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D2577-5 WEARSHOE

BREAK ALL SHARP CORNERS 0.010 TO 0.020  
MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570  
SERIES STEEL 0.063 THICK  
FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

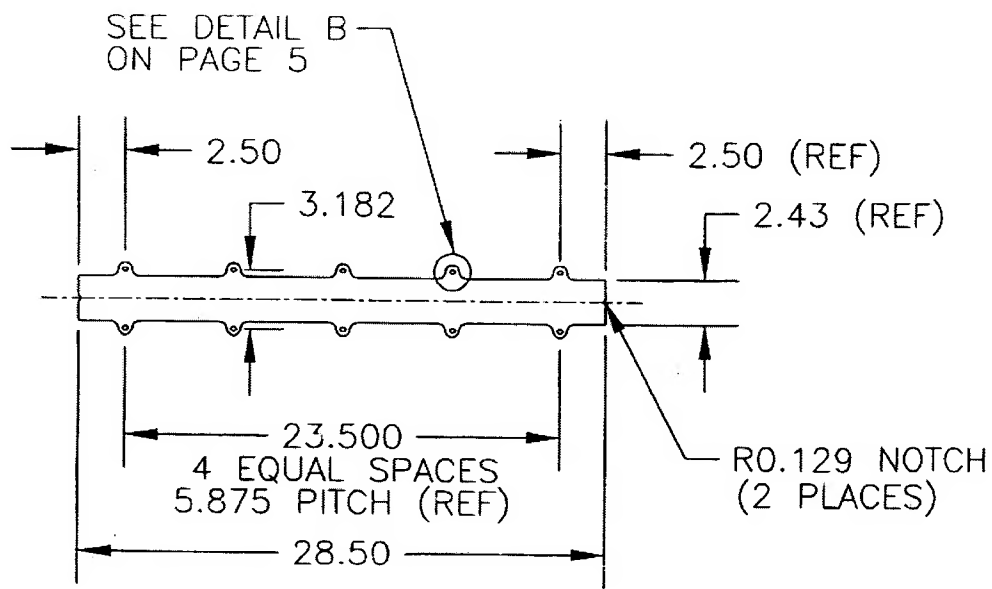




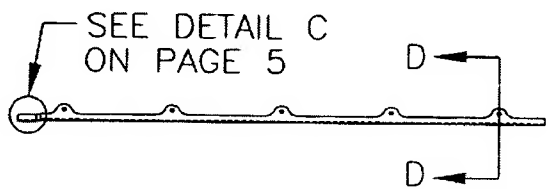
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DATE	DRAWING NO.	REV. E
00.09.22	D2577	SHEET 4 OF 5
	TITLE	SCALE
	WEARSHOE	1:10

RELEASED  
00.09.26

D2577-7 FLAT PATTERN



D2577-7 LONGITUDINAL BEND



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D2577-7 WEARSHOE

BREAK ALL SHARP CORNERS 0.010 TO 0.020  
MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570  
SERIES STEEL 0.063 THICK  
FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

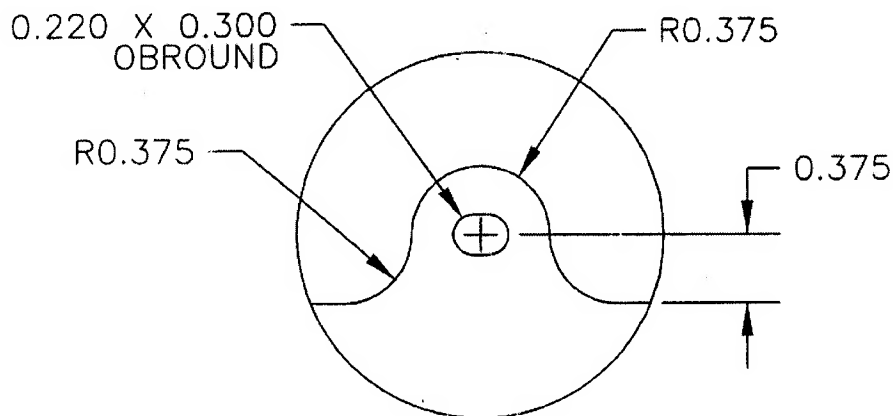
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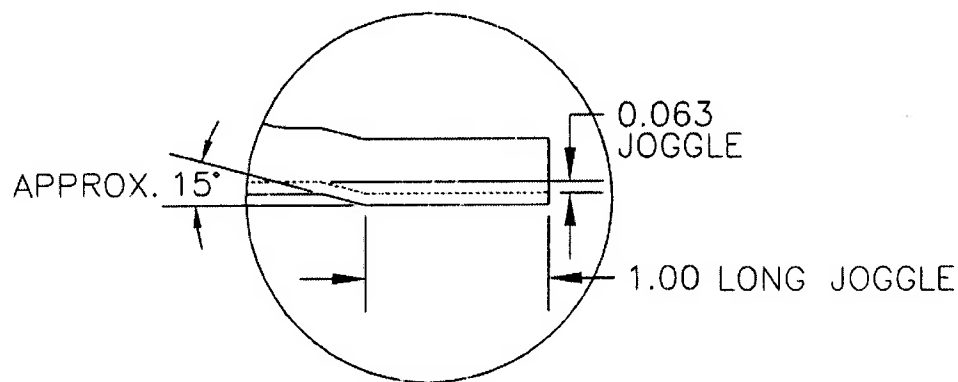
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CHECKED #	APPROVED #	DRAWING NO. D2577	REV. E SHEET 5 OF 5
DATE 00.09.22		TITLE WEARSHOE	SCALE 1:10

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00.09.26

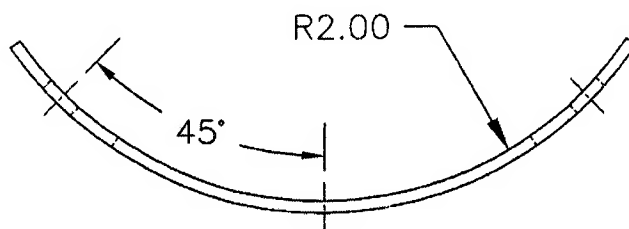
DETAIL B (SCALE 1:1)



DETAIL C (SCALE 1:1)



SECTION D-D (SCALE 1:1)



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